November-15-12 10:41:36 AM *N900040100* Accept Setup Start Item ID: 646.3511 **Revision ID:** Stop Item Name: Strut **Start Qty: 20.00** Start Date: 11/15/12 **Cust Item ID:** Req'd Qty: 20.00 Required Date: 12/07/12 **Customer:** Reference: Run Process Plan: MLゴ Date: 12-11-15 Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Set Up Tool ID Tool # Plan Reject Reject Accept Insp. Operation Sequence ID/ Qty Number Stamp Code **Oty** Description **Run Hours Work Center ID Revision Nbr** Draw Nbr 646.3500 N/C 110 0.00 *110* Jn011-25 0.00 Waterjet Memo 20 0 JM13-4-27 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg FLOW CNC Waterjet Dwg Rev: N/C Prog Rev: A)/C 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 120 *120* 0.00 QC Memo JM13-4-27 20 O Quality Control

					•						DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPD	ATE	QA Closed:	(V Date:	13/1/2
Work Orde	er:	4	1326	33		DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	(7)
Part N	- No	1.	46. 3-7	35		Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet X d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					1	iption of work order update	- 1	nitial	Actio		Sign &		
Cause		Date	Step	Qty		or Non-conformance	<u> Ch</u>	ief Eng			Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	X	dolo	641 100	n	Due do when of to us d	n forming and n forming and ube Apical autori no use Stainless S	re lee	DAS 15.	MEDITED Scrap All recut Soc obtain	place and	13.04.25	1945 196 196 196 196 196 196 196 196 196 196	(DAS) 16,13 13/04/29
онарриотес			1	<u> </u>	<u> </u>		FAUL	T CATE	GORY	·Kan			
Landi	一				۲	General Bend	$\overline{}$	Grain	n	1/2)	Ovalized		Pressure/Forced
	-	Bending Centre No	ot Concei	ntric to	o/s	BOM/Route	-	Hardwa	ire 🔏		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete	W / /	Part Incorred	-t [Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Work	Order	ID	93263
VVIII	USIUCI	117	プンムロン

93263

Page 2

November-15-1	2 10:41:36 2	4 <i>M</i>										
Item ID: Revision ID:	646.3511			Accept	*N900	040	100)*	etup St		N.	S1*
Item Name:	Strut								St	op 🛪	N.	52 *
Start Date:	11/15/12	Start Qty: 20.00	*20*		Cust Item I	D:						:
Required Date	: 12/07/12	Req'd Qty: 20.00	*20*		Customer:							
Reference:								_				•
Approvals:	Process Pl	lan:	Date:	Tooling:	Da	ate:		F		art 🛪	N	₹1*
	QC:		Date:	SPC (Y/N):	Da	ate:			St	op 🛪	N	₹2*
Sequence ID/ Work Center	(D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reje Nun	ect nber	Insp. Stamp
130		QC8- Inspect parts - seco	nd check	12AC 00.0				\sim				
130 QC Quality Control		Мето		0.00 15) <i>(</i>			<u>W</u>				
				*								
140				0.00								
140 Small Fab Small Fab		Memo 1- Fabricate	tube as per dwg	0.00				20	62	13-	5-8	} /
150		QC5- Inspect part comple	eteness to step on W/O	0.00								÷
150 QC Quality Control		Мето		0.00	13.5:2	/						

NCR:	Yes /	No				WORK ORDER NON-C	CON	FORI	MANCE / UPD	ATE			*; * '
	*										QA Closed:	Date	:
Work Ord	er:			<u></u>	<u> </u>	DISPOSITION	,			AGAINST DE	PARTMENT,]
Part I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ln	itial	Actio	on	Sign &	· · · · · · · · · · · · · · · · · · ·	
Cause	Da	ite S	itep	Qty		or Non-conformance	Chie	ef Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								And the second					
						F/	AULT	CATE	GORY				
Landi	ng Gear					General				<u></u>	•	_	_ ·
	Bend Cent Crack	re Not C	oncent	tric to C	D/S	Bend BOM/Route Broken/Damaged	٦	Grain Iardwa nspecti	re on Incomplete		Ovalized Over/Under Part Incorred	<u> </u>	Pressure/Forced Temperature/Cure Weld
	⊢ ⊸	ned/Crin	nped.			Burrs	-		ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				-	Contamination	\vdash		nance		Part Moved		•
	_	Treat		Cooke a	<u> </u>	Countersink	\vdash	/lislabe		<u> </u>	Positioned W	_	T _{out} .
		ection St	•	ube	-	Cut Too Short		/lisreac	I		Power Loss/:	Surge	Other
		es in Be		.a		Drill Holes	\vdash	Offset	Saltharaktara			•	
		ue Wave ing Sequ		urusion	' ⊢	Drawing Finish	\vdash		Calibration Sequence				
	l liain	mg acda	CHC			1 1111211	1 1	out Of 3	requerice				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93263 Page 3 November-15-12 10:41:36 AM *N900040100* Accept Setup Start 646.3511 Item ID: **Revision ID:** Strut Item Name: 11/15/12 Start Qty; 20.00 **Start Date: Cust Item ID:** Required Date: 12/07/12 Req'd Qty: 20.00 **Customer:** Reference: Run Start Tooling: Date: Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: OC: Tool ID Reject Reject Tool # Plan Sequence ID/ Set Up/ Accept Insp. Operation Code Qty Qty Number Stamp Description **Run Hours** Work Center ID Weld per dwg A/R Aluminum rod Batch: 112 2357 0.00 160 EZ 13-5-21 *160* Large Fab 0.00 Memo Weld tube to plate as per dwg. Large Fab Weld end were tube is punch. QC9- Inspect visual per QSI004- Fusion Welds 0.00 170 *170* 0.00 OC Memo Quality Control 0.00 OC5- Inspect part completeness to step on W/O 180 *180* 0.00 QC Memo Quality Control

												DQA:	Dat	.e: _	•
NCR:	es /	No					WORK ORDER NON-O	COI	NFORI	MANCE / U	PDATE	QA Closed:	Dat	:e:	A 783
Work Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N NCR N	 lo		,				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Des	cri	ption of work order update	П	nitial	A	Action	Sign &		T	"
Cause	D	ate	Step	Qty			or Non-conformance	1	ief Eng	Des	scription	Date	Verification	١	QC Inspector
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upplier		1											İ		
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Inapproved								1							
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Landi	ng Gear						General		_			-	_		
	Ben	ding					Bend		Grain			Ovalized		P	Pressure/Forced
	Cen	re No	t Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance		emperature/Cure
	Crad	ks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	\v	Veld
	Crus	hed/C	rimped.			•	Burrs		Instruct	ions Incomplete	e/Unclear	Part Lost/Mi	issing	\v	Wrong Stock Pulled
· ·	Cuff	s					Contamination		Mainte	nance		Part Moved	•		į
	Hea	Treat	:		į		Countersink		Mislabe	led		Positioned V	Vrong _		
	Insp	ection	Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	′Sürge [Other
	Ripp	les in	Bend				Drill Holes		Offset						
	Tord	ue Wa	aves in E	xtrusio	า		Drawing		Out of 0	Calibration					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Orde November-15-12	er ID 93			*932	263*						Page 4
Item ID: Revision ID:	646.3511			Accept	*N900	040	100)* s	etup Sta	-1 🚺	S1*
Item Name:	Strut								Sto	P *N	S2*
Start Date:	11/15/12	Start Qty: 20.00	*20*		Cust Item II	D :					
Required Date: Reference:	12/07/12	Req'd Qty: 20.00	*20*		Customer:						· · · · · · · · · · · · · · · · · · ·
Approvals:	Process Pl	an:	Date:	Tooling:	Da	te:		R	un Sta	171	R1*
	QC:		Date:	SPC (Y/N):	Da	te:			Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Outsource4 Outsource process -	Anodize	Outsource process-Anodia Memo Issue P/O: Anodize as p		0.90					 7	· 	
*200 *200* Packaging Packaging		Receive & Inspect for Dar		0.00		13	04	·)			; ; ;
*210 *210*	V	QC5- Inspect part comple	teness to step by W/O	0:00		-					. '
OC		Man	/ "	0.00						_	

Quality Control

NCR:	Yes	/	No

											DQA:	Date:	· .
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UP	DATE			***
											QA Closed:	Date:	:
Nork Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
,, or a						Rework	٦	i	Skid-tube	Crosstube] .	Water Jet	Engineering
Part	No.					Scrap	7	[1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			•			Use-as-is	7	Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR	No.					Work Order Update	7		Large Fab	Composite		Supplier	
Root					1	ption of work order update	- 1	Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data											,		
quip/Tooling	<u> </u>							!	·				
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rocess	\vdash												
upplier	\vdash												
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napproved	<u> </u>	<u> </u>	!				ΕΔΙΙΙ	T CATE	SORV			<u> </u>	
Land	ing (Gear				General	7.0.	Oitte	 				
	٦	Bending				Bend	Г	Grain			Ovalized	Г	Pressure/Forced
		1	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	-	Over/Under	tolerance	Temperature/Cure
		─-			Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ļ	Weld	
	Cracks Broken, Crushed/Crimped. Burrs			1		1	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Γ	Cuffs	•			Contamination		Mainte	-	:	Part Moved	-	-
•	Heat Treat Countersink					Countersink	Mislabeled Positioned Wrong						
Inspection Strip in Tube Cut Too Short						Cut Too Short	Misread Power Loss/Surge Other			Other			
		Ripples in	Bend			Drill Holes	Offset				<u> </u>		
		Torque W	aves in F	xtrusio	,	Drawing		Out of (Calibration			<u> </u>	

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Ord November-15-12				*932	263*						Page 5
Item ID: Revision ID: Item Name:	646.3511 Strut			Accept	*N90	00040	າ1ດ()*	Setup Star	רימו	1* 2*
Start Date: Required Date: Reference:	11/15/12	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Ito					I WIT	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:			Run Star Stop	"INK	!1* !2*
Sequence ID/ Work Center II 220 *20* SprayPaint Spray Painting	D	Operation Description Memo Prime as per	. dwg (see note 3)	Set Up/ Run Hours 0.00	Tool l	(D Tool :	# Plan Code	Accep Qty	Qty	Number S	nsp. Stamp 05-23
230 *230* QC Quality Control	•	QC14- Inspect Spray Pain Memo	t	0.00 AS 16 0.00 9-89	Blustzu		(20 courses			
240		Receive & Inspect for Da	nage & Mat'l Certs	0.00						1	

740 Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV

(43/s/24/20)

												DQA:	Date:	•
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPD	OATE	QA Closed:	Date:	n cay 💌 👻
Work Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR	No.						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. ee/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desc		otion of work order update	1	nitial ief Eng	Acti Descri		Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved														
			-				F/	AUL	T CATE	GORY				
Landi	ng (Gear			_		General		•			•		,
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped t n Strip in		D/S		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			on Incomplete ions Incomplete/U nance led	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W		xtrusior	,	_	Drawing			Calibration			·	
		Turning Se			<u> </u>	⊣	Finish			equence				

Outside Dimensions

Wave/Twist in Tube

Folio

Work ()r	de	r ID	9326
November	15	12	10.11.	36 AM

Page 6

November-15-1.	2 10:41:36	4M		9.57	(D.)						
Item ID: Revision ID:	646.3511			Accept	*N900	040	100)* s	etup Star	IA	S1*
Item Name:	Strut				•				Sto	• *N	S2*
Start Date:	11/15/12	Start Qty: 20.00	*20*		Cust Item 1	D:					
Required Date:	: 12/07/12	Req'd Qty: 20.00	*20*		Customer:						
Reference:							_		Run Stai		
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:		ŀ		1/1	R1*
•	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250		QC21- Final Inspection -	Work Order Release	0.00						1/10	\mathcal{M}
250 QC Quality Control		Memo		0.00					_12	5/2	4
Quality Control			-						N/13-1	ys-24	! !

									DQA:	Date:	•
NCR:	Yes / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			•
						_			QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		1	ĺ	Descri	ption of work order update	Initial	Λ.	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	i	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
						AULT CATE	GORY				
Landii	ng Gear			<u> </u>	General			_	1	<u></u>	1
	Bending Centre No	ot Concer	ntric to (o/s	Bend BOM/Route	Grain Hardwa	are		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		tion Incomplete		Part Incorre		Weld
	Crushed/	Crimped.			Burrs	⊢⊣	tions Incomplete/	'Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination	H	enance		Part Moved		
	Heat Trea			<u> </u>	Countersink	Mislabe		<u></u>	Positioned V		7
	Inspection		Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
;	Ripples in	Bend			Drill Holes	Offset			****		
	Torque W	aves in E	xtrusion	1	Drawing	Out of	Calibration				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order ID: Parent Item: Parent Item Name:	93263 646.3511 Strut			,					rt Date: 11/15/	12	Required D		
Comments: Component Item ID/ Item Name	Replacement Item ID	Mfg/ .	DD VE Bin Item	RF:JLM Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
16061T6S-100 2		Purchased	No				sf	40.7000	,	0.58526 O.6	32		Jour-
	5 .068" H.	Ne 人 Purchased	No	118 118	2201 8072 8523 4572	40.7 0.5 5.6 34.6	<u>Lo</u>	c Code 124.3000	118	523 5173431 -El		-21	
25 M304		649 . د		Location MAT014	2083	Loc Qty 124.3 124.3	<u>Lo</u>	c Code		· · ·			

See attach E-Mails

REF.

ECD 13-033

P. 13-033

P. 13-033

					WORK ORDER NON	CANCODA	AANCE / UD	DATE	DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	LONFORI	WANCE / UP	DATE	QA Closed:	Date:	,
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data										8.5	,
Equip/Tooling											
Operator						}					
Material											
Setup											
Other									:		
Process											
Supplier											
Training			1					C1			

Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Weld Inspection Incomplete Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Countersink Heat Treat Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Other Power Loss/Surge Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Unapproved

--3 >		ENGINEER	ING CHANGE		Λ	02440	SHEE		ÖF 1
A	PICAL	DWG NO.	646,3500 F	REV: NC	REPARED S. H	HUFF (DAT)	E/106/08/09	EFFEC	WO NO T
INDU	STRIES, INC.	DWG TITL		MFG	STRUT	1 00	LEFF! CUF	RRENT ORDER	R AND STO
TRANSA A-ADI R-RE\	CTION CODES (TC) C-CREATE VISE D-DELETE	REASON: RE	VISED GEOMETR	Y TO ACCEMI	DATE NEW	EXISTING AIRC	RAFT PROVIS		
: 									
	SHEET 2 IS:	54'			SHOD COME SHOD SHOD STANDARD		-	>	:
			130	SUB.	ONTROLE DE L	(*)			,
					93263M	LJ 1-15			1
					12-1	,	646.3512 SHOWN -646.3513 OPPOSITE		!
·		17	72			.100] [1 0 2 1 1 3
	(825)	36*	R 650		28.				;
		7.50		2.00			·		:
	<u> </u>	100 -4 90		•	200	20			1
		. (5:	51>						
DOCUME	INTS EFFECTED		NSTALL INSTRUC	□ ICA □ FM	CHA	NGE CATEGORY	DER REVIEW	REQUIRE	D
**************************************		·	,						

•	ENGINEER	RING CHANGE	NOTICL	NO.	02197		SHEET	1 [JF 1
APICAL	DWG NO.	646.3500 R	EV:N/C	PREPARED S.	HUFF	DATE: 01/	05/09	EFFECT INC.	ON DWG WUNINC.
INDUSTRIES, INC.	DWG TITL			STRUT					·
	APPROVED BY: EN	married I	MFG/	Sluke	QC ×		EFF:	NEXT D	IRDER
TRANSACTIUN CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: R	VISED ANGLE OF	646.3512	& 646,3513	FOR BET	JER PI) MENT			!
SHEET 2, IS	715	385°.	72 R 65	200	393° 200 375	N.20	DEVIEW B		
DOCUMENTS EFFECTED:		NSTALL INSTRUC	□ ICA □ F	MS D BOM C	HANGE CAT MAJOR 🗵	EGURY DER		EQUIRED I NO	

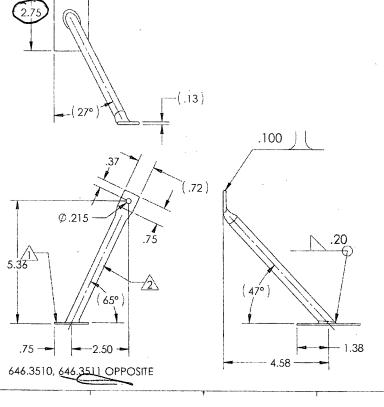
NOTES:

MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11; .062" THK.

MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6 .500" OD; .062" WALL THK

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2 COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N

- 4. DEBURR AND BREAK ALL SHARP EDGES
- 5. WELDS IAW MIL-STD-2219, TIG WELD WITH FILLER ROD



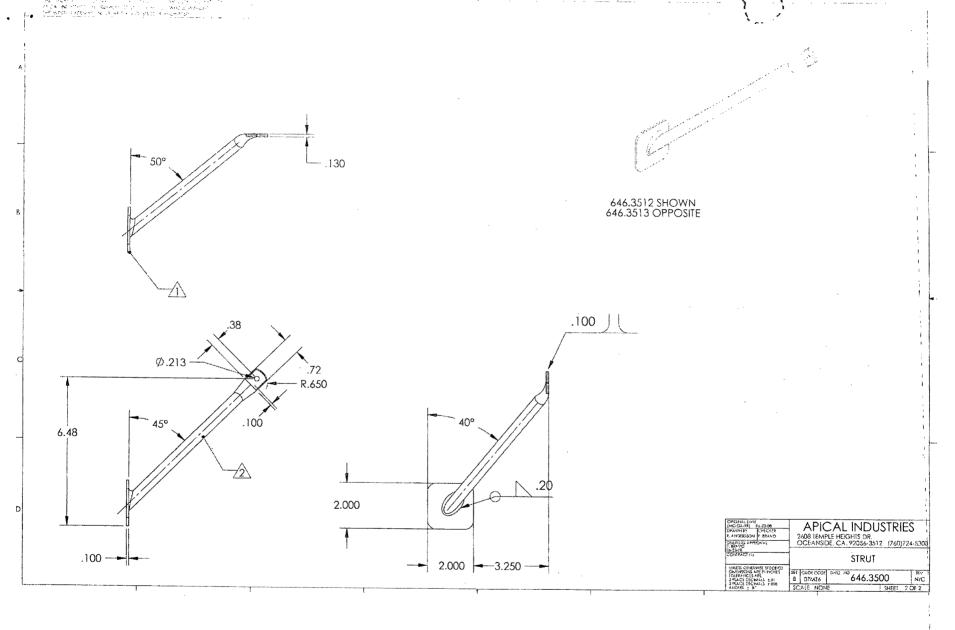


646.3510 SHOWN 646.3511 OPPOSITE

UNINCORPORATED ECN(s)

02197, 02440

		646.3513	STRUT		△
		646.3512	STRUT		A
		646.3511	SIRUT		(3)
		646.3510	STRUT		A
	FIND #	PART#	DESCRIPTION	MAT'I	SPEC.
QīY			PARTS LIST		
NEXT ASSY 646,4000	(5) (5.4% E-4:4	CAL DATE OF 22 CB INFT OF 22 C	APICAL 2606 TEMPLE HER OCEANSIDE, CA	SHIS DR.	
	GC3/ff	RACT No.		STRUT	
	Division Control	SS OTHERWISE SPECIFI HISTORIS APE IN FECHE EARLICES ARE: LOF CECIMALS: ±01 LOF CECIMALS: ±035	SRF CAGE CORE DAYS N	646.3500	N/C



DART AEROSPACE LTD	Work Order:	93263
Description: Plate Start	Part Number:	1111 3-101
)		1946 STEC
Inspection Dwg: 646.3500 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	ARTICLE IN Actual Dimension	Accept	Reject	Method of Inspection	Comments
. [2.75"	11-0.010	2.75411			<i>U</i>	Production
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	6.063"	11-0-010"	0.058"	~	 	V	<u>.</u>
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Į	-	JM 13-4-27					

Measured by: JM

Date: 12-11-75

Pate: 15

Preliminary Approval:

Date:

David Duval

From:

Pablo Bravo

Sent:

Wednesday, April 24, 2013 2:23 PM

To:

Jean-Luc Menard

Cc:

David Duval; Linda Lacelle

Subject:

RE: 646.3510/3511/3512/3513 STRUT ASSY

JL,

This should be okay.

Pablo

From: Jean-Luc Menard

Sent: Wednesday, April 24, 2013 9:15 AM

To: Pablo Bravo

Cc: David Duval; Linda Lacelle

Subject: Fwd: 646.3510/3511/3512/3513 STRUT ASSY

Any news on this?

Sent from my iPhone

Begin forwarded message:

From: Jean-Luc Menard < imenard@dartaero.com >

Date: 22 April, 2013 10:27:05 AM EDT

To: Pablo Bravo pbravo@dartaero.com

Cc: David Duval < dduval@dartaero.com >, Linda Lacelle < llacelle@dartaero.com >

Subject: 646.3510/3511/3512/3513 STRUT ASSY

Hi Pablo,

We have started manufacturing the struts and have run into some problems with cracking when punching/bending the end of the struts.

Would going to 304 ss tubing with .049" wall be an acceptable deviation? This would include changing the bottom plate that gets welded on also to SS. Let me know asap so I can attach to the w/o and if acceptable I will issue a ECR.

THX

JL